

# Work Order ID 55982

February 8, 2010 2:27:50 PM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 2/08/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

*PH*

Date: 10-2-08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c'sink as per dwg

4- remove identification markings

5- deburr

SAN

10-02-09

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: ~~M113~~ M109213

7- grind weld flush

8- deburr if necessary

⑥

*Cpl 10/02/11*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




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Page 2

Item ID: D3827-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Rib Assembly (Inboard)					
Start Date: 2/08/10	Start Qty: 6.00		Cust Item ID:		
Required Date: 2/12/10	Req'd Qty: 6.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00	Satisfy			(46)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	Satisfy			(46)	f		
150  Packaging Packaging	Identify as per dwg & Stock Location: <u>Basket</u>  Memo	0.00  0.00				D	10.02.11	(C)	



W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Work Order ID 55982

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Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 2/08/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/12

W100212

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 55982

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboard)

Start Date: 2/08/10

Required Date: 2/12/10

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	61.0000	18.0000			
---------	--	--------------	----	--	--	-----	------	---------	---------	--	--	--



Bushing

*Epl 10/02/11*

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

WA	61	
53442	2	
54072	9	
55093	14	
55789	36	

M304TS0.750W.065

Purchased

No

100

f

143.6815

50.5263



304 SQ Tube .75x.75x.065W

*17 Epl*  
*11 Epl*

*SAD 10-02-09*

Warehouse	Loc Qty	Loc Code
-----------	---------	----------

Location

Main Warehouse

MAT	143.6815242	
113082	0.00419	
113245	0.00038421	
113683	33.15065	<i>x2</i>
113836	110.5263	<i>x4</i>

Main Warehouse

WA	0.0000047	
112398	0.0000047	

*16.8421*  
*33.6842*

W/O:		WORK ORDER CHANGES					
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

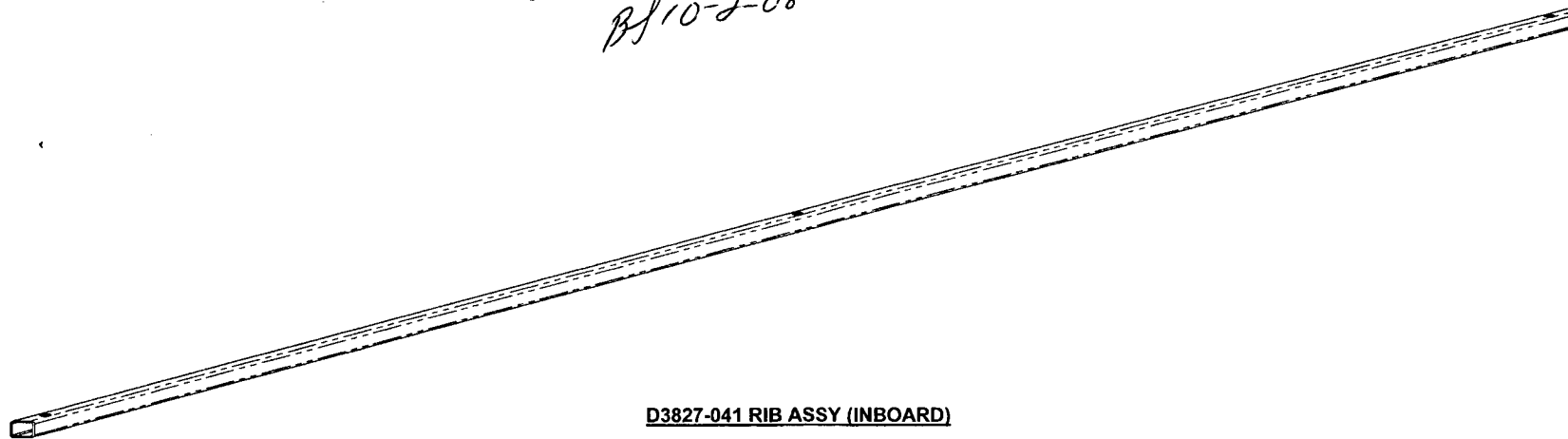
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SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55982  
Bf10-2-05

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3759-1	BUSHING
3	1	D3827-1	RIB



D3827-041 RIB ASSY (INBOARD)

RELEASED  
08/11/18

- NOTES:  
1) MATERIAL: N/A  
2) FINISH: NONE  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	
DRAWING NO. D3827		SHEET 1 OF 3	
TITLE RIB ASSY (INBOARD)		SCALE NTS	
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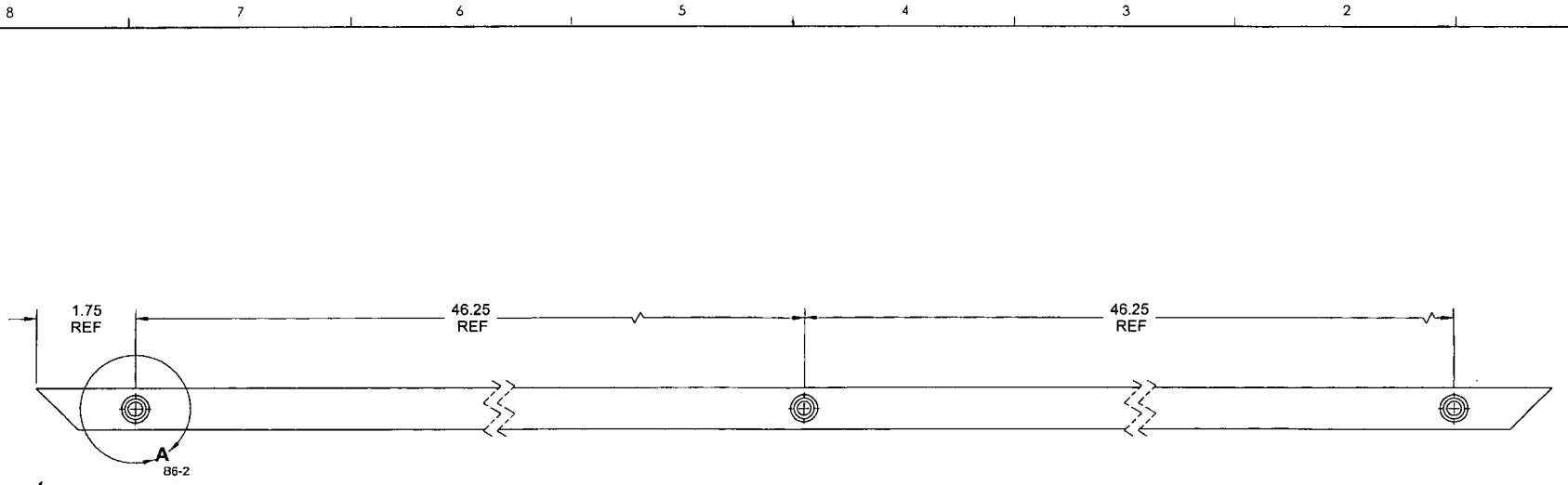
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

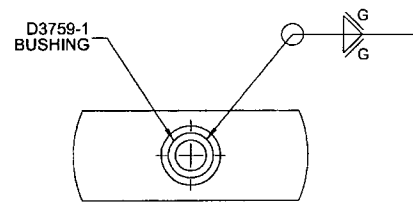
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**NOTE:** Date & initial all entries



**D3827-041 RIB ASSY (INBOARD)**



**DETAIL A**  
SCALE 2X  
3 PL

*W/D 55982*

**RELEASED**  
*08/11/18*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>MS</i>	<b>D3827</b>	SHEET 2 OF 3
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	<i>MS</i>	<b>RIB ASSY (INBOARD)</b>	NTS
DATE	<b>08.09.23</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

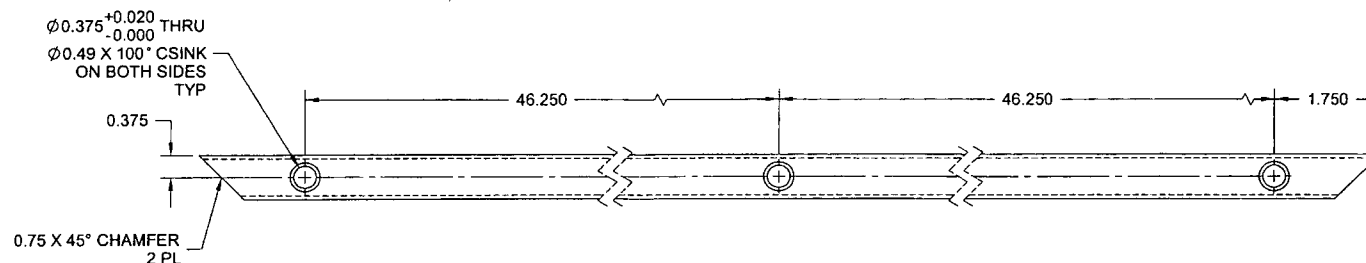
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**D3827-1 RIB**

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.55 lbs

DESIGN		<b>RELEASED</b> 08/11/23 W/055982 <b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
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